

OP1.1 General Overview

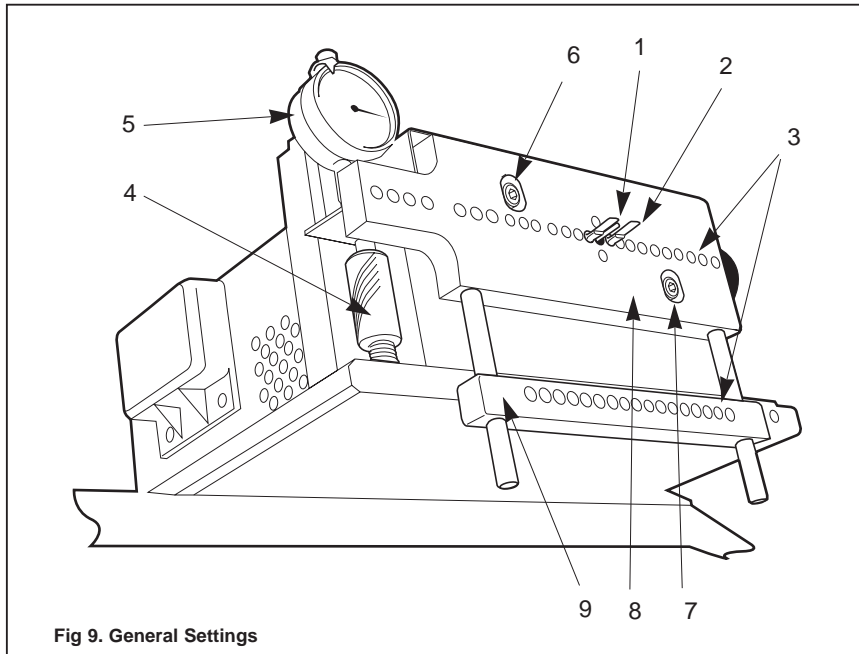


Fig 9. General Settings

WARNING: ISOLATE MACHINE FROM POWER SUPPLY BEFORE CARRYING OUT ANY ADJUSTMENTS

- 1. Cutter Tooling
- 2. Location Pins
- 3. Pin Location Holes
- 4. Fine Cutter Adjuster
- 5. Dial Guage
- 6. Position Lock Bolts
- 7. Adjustment Bolt
- 8. Positioning Block
- 9. Lower Block

The Location Pins (2) can be positioned adjacent to the Cutter (1) or any of the Pin Location Holes (3) depending on the job requirement.

Select Pins that are a slide fit in the routed channel. Select positioning holes depending on the size of web to be removed. Web must fit between cutter and pin - on either side - with enough free space to allow movement of the board through the cut.

OP1.2 Setting Procedure

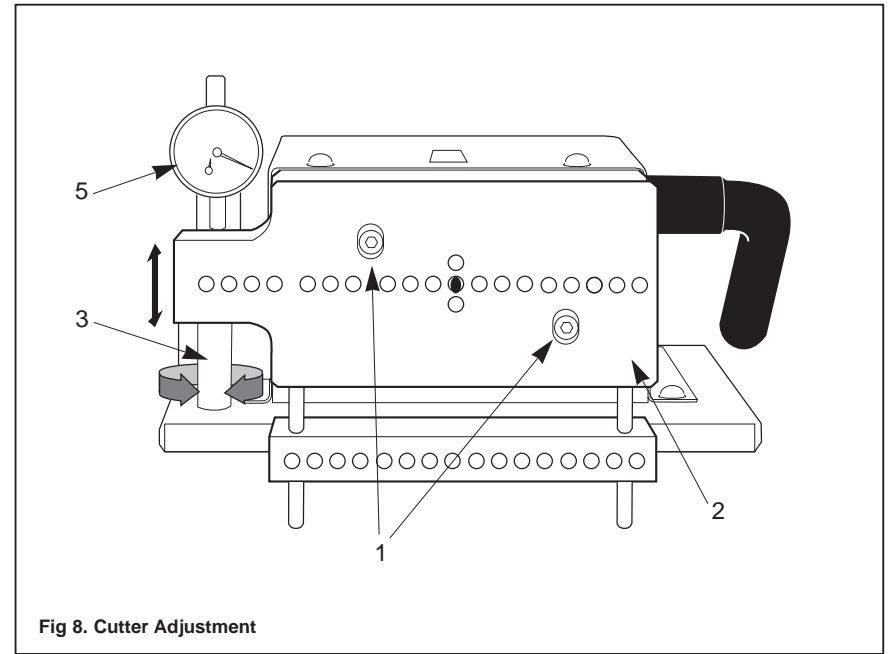


Fig 8. Cutter Adjustment

WARNING: ISOLATE MACHINE FROM POWER SUPPLY BEFORE CARRYING OUT ANY ADJUSTMENTS - CUTTER TOOLS ARE VERY SHARP & DELICATE!
HANDLE WITH CARE

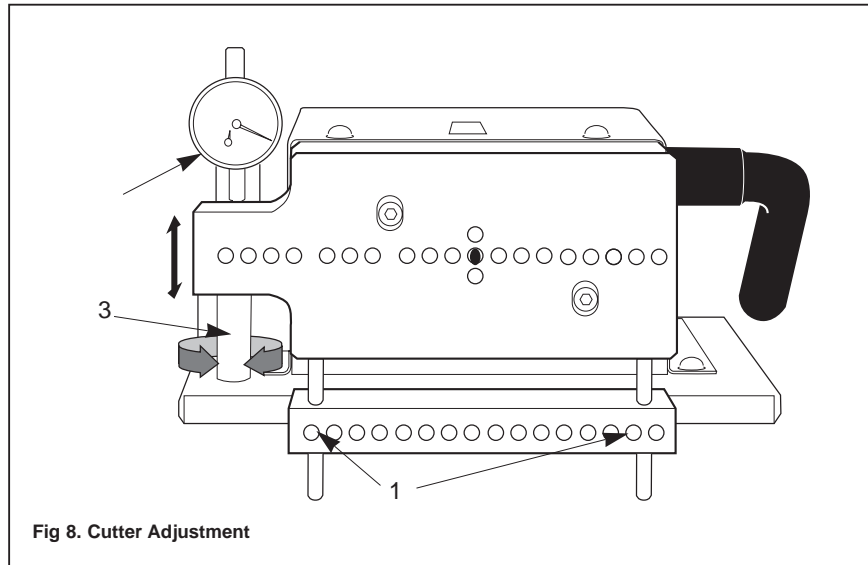
IMPORTANT: It is important to establish how much adjustment, to the depth of cut, is required. Always start adjustments from zero.

- 1. Loosen two hex head screws just enough to allow movement of the positioning table.
- 2. Position a straight edge rule across the cutter face/positioning table.

NOTE: Use a matchstick or similar to rotate the cutter tool until one of the blades is at full height

- 3. Using the knurled adjuster, lower or raise the table until the cutter is in contact with the straight edge.
- 4. Tighten two screws
- 5. Once satisfied, reset the dial gauge to zero.
- 6. Run a test board and from the result determine the amount of additional adjustment required.
- 7. Repeat items 1,3 & 4 using the dial indicator to meter the exact adjustment.

OP1.3 Adjustments



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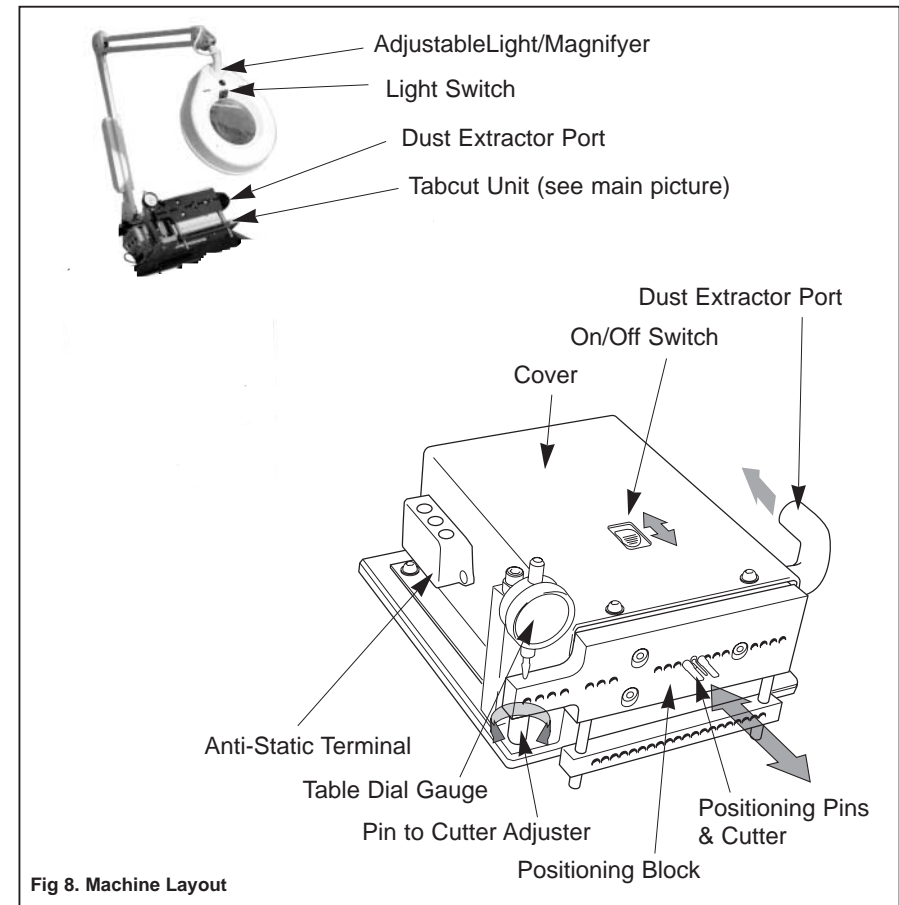
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0.4 Layout & Controls



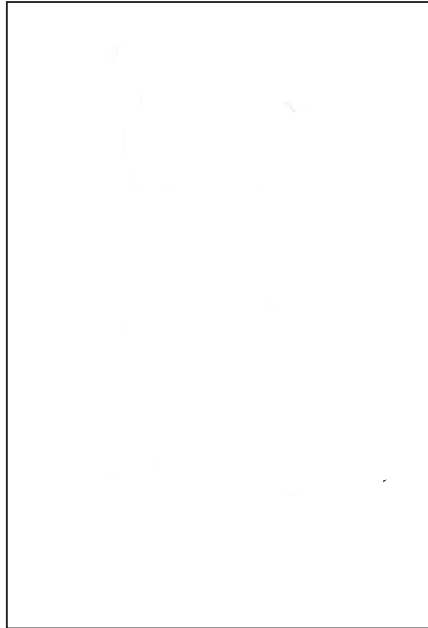
WARNING: DO NOT ATTEMPT TO OPERATE THIS ITEM UNTIL COMPLETELY FAMILIAR WITH THIS MANUAL.

This General Layout refers to components referenced throughout this manual. Read section OP1 before continuing

NOTE: A Vacuum supply must be available and activated before the Tabcut unit is turned on - a 30mm extractor port, built onto the Tabcut unit, must be connected to the Vacuum supply.

WARNING: Failure to use vacuum may result in build up of static and damage to board or components.

0.3 Installation



1. Uncrate the Tabcut machine and position it with sufficient work space around it (see figure 1).
2. Ensure all components are present (See Check List Section 0.2)
3. Locate the unit close to a 13 amp power socket
4. Consideration should be made for stacking space adjacent to the unit for panels and separated pcb's
5. Read & Fully understand the Safety Instructions (below) and Operator Manual before turning the unit on.
6. The Manufacturer recommends the use of an adjustable stool while operating this equipment

Safety Instructions

1. Read this instruction manual carefully BEFORE operating the machine. Do not attempt to operate the machine until you are totally familiar with its safe operation.
2. Do not operate the machine without the magnifier/light in operating position. **Always** view through the magnifier when operating this machine
3. Do not tamper or modify any safety guards or devices.
4. Do not perform any setting up procedures with the machine switched on.
5. Do not place hands near the cutter whilst machine is in use.
6. Do not wear loose clothing, jewellery or unrestrained hair styles whilst operating this machine.
7. Always disconnect the power supply from the machine BEFORE carrying out repairs or maintenance.
8. Always wear safety glasses or a face shield and ear protection when operating this machine
9. Always wear gloves when replacing cutters
10. This machine MUST be operated by only ONE person at a time.
11. Ensure effective exhaust of dust before operating this unit

MT2.1 Maintenance

WARNING: ISOLATE MACHINE FROM POWER SUPPLY BEFORE CARRYING OUT ANY MAINTENANCE

Tabcut has been designed for very low maintenance. However, it is vital that regular inspection of the cutter be carried out by the operator.

DAILY

1. Check Cutter condition
2. Check & empty vacuum dust bag
3. Ensure Full Static discharge before operating with boards (checks should be made with vacuum in operation)

MONTHLY

1. Check Motor Drive Brushes for wear (replace if necessary)
2. Vacuum any dust found on the cutter motor or inside the cover. Dust drawn into the motor may cause bearing failure.
3. Remove Anti-static armature poleand check contact plug for wear.

MT2.2 Cutter Removal

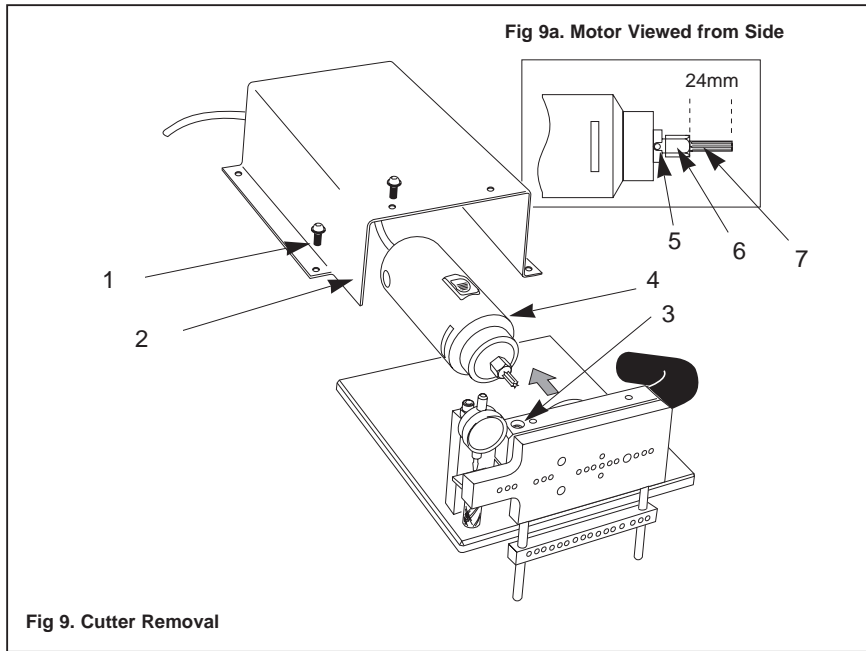


Fig 9. Cutter Removal

WARNING: ISOLATE MACHINE FROM POWER SUPPLY BEFORE CARRYING OUT ANY MAINTENANCE

1. Remove six Cover securing screw
2. Lift cover away (it is necessary to feed the power cable through the grommet at the rear of the cover)
3. Loosen the 10mm hex socket clamp screw.
4. Withdraw the motor assembly from the clamp block.
5. Install Rotor locking tool bar.
6. Use chuck spanner in conjunction with rotor locking tool to release the cutter tool.
7. Use protective gloves to withdraw

and handle cutter tool.

NOTE: NEVER handle cutter tool with bare hands. Always wear gloves.

8. Installation is the reverse of removal - Ensure the power switch is located at the top when repositioning the motor.
9. The cutter tool must be installed with a cutter length of 24mm from the chuck. (See Fig.9a)
10. Locate motor fully home to shoulder before tightening clamp screw. Do not over tighten clamp screw or damage to motor will occur.

0.2 Technical Data Specification

Length	420mm
Width	420mm
Height (including stand & magnifier) max.	1125mm
Weight (including stand & magnifier)	23.5Kg

Cutter Speed	28,000rpm
Cutter diameter & angle	ø1.6/2.0/.2.4mm parallel
Board positioning	Ground Location Pins
Cutter depth adjustment	Hardened & Ground Adjustable Table
Exhaust Vacuum Requirements	50cfm (minimum)
Electrical supply	Single phase 240V x 6amp

Check List

The following equipment has been packed and checked before despatch. Uncrate the Tabcut CAREFULLY! Do not handle Tabcut roughly. Ensure that all of the equipment is unwrapped from its individual packaging before discarding the packaging.

IMPORTANT NOTICE

The guarantee on this equipment will be invalidated if damage occurs either through negligence, mishandling or incorrect installation.

Packing List

- Tabcut machine with Cutter (fitted).
- Set of Allen key tools
- Cutter chuck locking tool & spanner
- Spare fuses
- Cabling & plug
- Adjustable Light/Magnifier



The manufacturer. reserve the right to change or alter the specification without notice.

0.1 Introduction

Design Principles

Tabcut has been designed to depanel routed boards, applying a precise controlled edge to PCBs, without stress.

Tabcut is designed for simplicity and effortless operation, achieving clean-cut results without damaging board or components which are installed. Its primary objective is board separation without panel or component stress. It will eliminate the need for time-consuming and often inaccurate manual finishing methods, providing a clean, consistent edge for more accurate assembly.

Tabcut has a variable location table which provides quick and accurate adjustment of location pins, achieving perfect results.

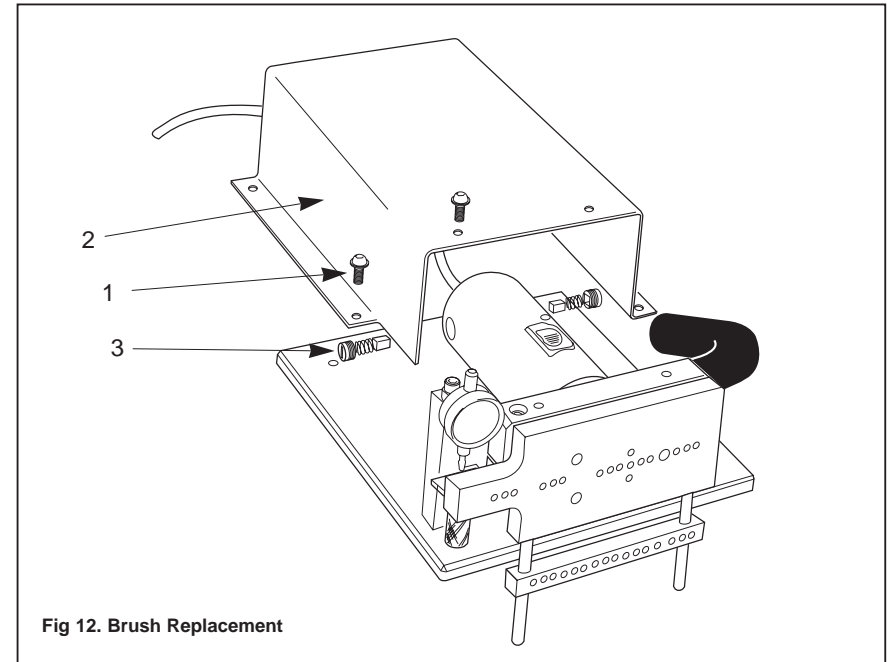
Interchangeable location pins ensure the boards consistent relationship with the cutter- irrespective of design style.

Construction

The unit consists of a zinc plated steel chassis with polished stainless steel cover. The fixed speed carbide cutter provides exceptional edging capabilities for any pcb material.

The Unit is supplied with stand, adjustable light/magnifier and hands-free foot control and 13 amp single phase cabling ready for installation and set up which can be carried out in less than 5 minutes.

MT2.3 Motor Brushes



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1. Remove six cover retaining screws.
2. Feed power cable through grommet at rear of cover and position cover to one side.
3. Remove plastic brush cover and withdraw brush/spring assembly
4. Unclip brush/spring assembly from cap and replace.
4. Reassembly is the reverse of removal.

SY3.1 Fault Finding

PROBLEM	REASON	SECTION
TABCUT NOT WORKING	Check fuse in switch or plug Check cable is installed Check power switch is ON	IN 0.4
TABCUT POWERS UP BUT DOES NOT CUT	Cutter tool is loose in chuck Positioning table is too high	MT2.2 OP1.2
INTERMITTENT TRIMMING & ROUGH EDGES	Damaged or worn blades Not enough pressure applied to locate board	MT2.2
BOARD WILL NOT ENTER GUIDES	Adjust Guides	OP1.1
BOARD ENTERS GUIDE BUT LABOURS PAST CUTTER	Positioning table too low or adjust guide clearance	MT2.2 OP1.1
LARGE ACCUMULATION OF DUST	Dust extraction inoperative or receptical full	CHECK
EXCESSIVE VIBRATION	Worn bearings or overtightened motor clamp	MT2.2

SY3.2 Noise/Vibration Info

Measured values determined according to EN50 144.
Typically the A-weighted sound pressure level of the tool is 82 dB (A). The noise level when working can exceed 85 dB (A). Wear ear protection!
Typical weighted acceleration is 4m/s²

CE Declaration of Conformity

We declare under our sole responsibility that this product is in conformity with the standards and standardization documents: EN 50 144, EN 50 014, EN 60 555, HD400 according to the provisions of the regulations 73/23/EEC, 89/336/EEC (as of 1/96), 89/392/EEC.



Mr Stephen Cooper
Seetrax CAE Ltd

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SY 3.3 Warrantee

General

Replacement will be furnished of parts found to be defective in workmanship or material, under normal one-shift conditions, within six months from the date of shipment, upon receipt of the defective goods at our factory. All necessary items or equipment furnished by us with this equipment are subject to the warranty issued by, or considered standard practice, by the representative manufacturers and is warranted or guaranteed by us accordingly.

There will be a charge for service calls made by our technicians if the calls are proven to be unnecessary due to the failure of your maintenance department to follow corrective measures on problems given during telephone conversations with our engineering department. These charges will be made at our normal service charge rate.

No claims will be entertained for loss of production whether related to the use or equipment or delivery of equipment or consequential loss or damage to business incurred by the buyer. No allowance will be made for repairs or alterations unless specifically authorised by the manufacturer.

Exemptions

Carbide cutters etc supplied with is machine are not covered by this warranty.

This warranty will be invalidated if non-Genuine Parts are used on the equipment.

Important

Always quote the Units Serial Number - found at the front of this manual and on the side of the machine - when ordering parts or service.

Supplied by:

Tabcut

OPERATORS MANUAL
(INCORPORATING SERVICE, MAINTENANCE
& SPARES SCHEDULES)



MANUAL